


Date: Thursday, 4/19/2007 10:06:22 AM
 User: Eric Charbonneau

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ARM
Job Number :	31954		
Estimate Number :	12590		
P.O. Number :	N/A	Part Number :	D35604
This Issue :	4/19/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3560 UNDER REVIEW
First Issue :	N/A	Project Number :	N/A
Previous Run :	31447	Drawing Revision :	A
		Material :	N/A
Written By :		Due Date :	4/23/2007
Checked & Approved By :		Qty:	1
Comment :	Est Rev:A New Issue 06-11-10 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 0.7350 f(s)/Unit Total: 0.7350 f(s)

6061-T6 Bar .50" x 6.0"

Batch: M10719 X ml 070419 (1)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: U/RProg Rev: U/R ml 070419 (1)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine as per Dwg D3560 ml 07/04/20 (1)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 0704.20 (1)

6.0	QC8	SECOND CHECK ENGINEERING APPROVAL
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Comment: SECOND CHECK ml 0704.20 (1)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 31954

Part Number: D35604

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W25*

FOR ENGINEERING USE ONLY

16.02.04.24 /

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1607104/25 (1)

Job Completion

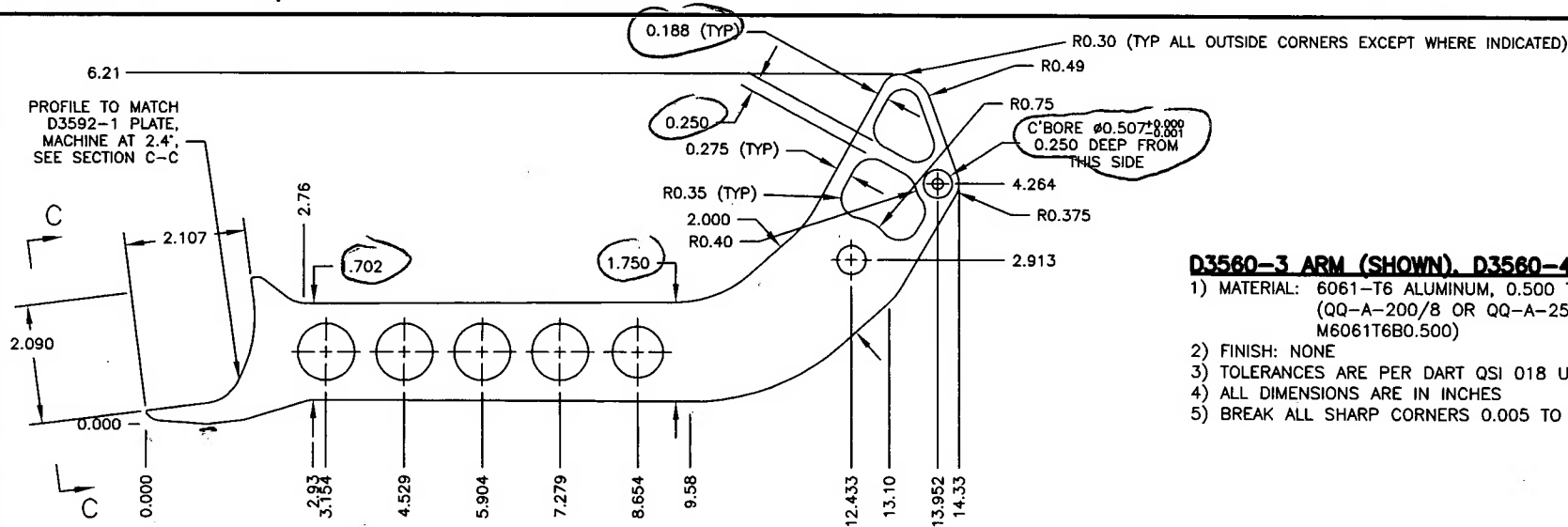


change 00075

1607104-25

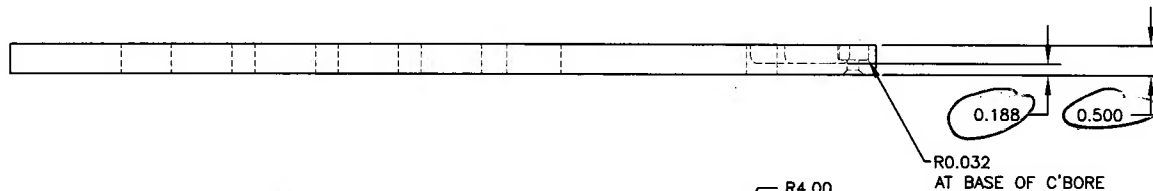
PRELIMINARY ISSUE

PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4",
SEE SECTION C-C

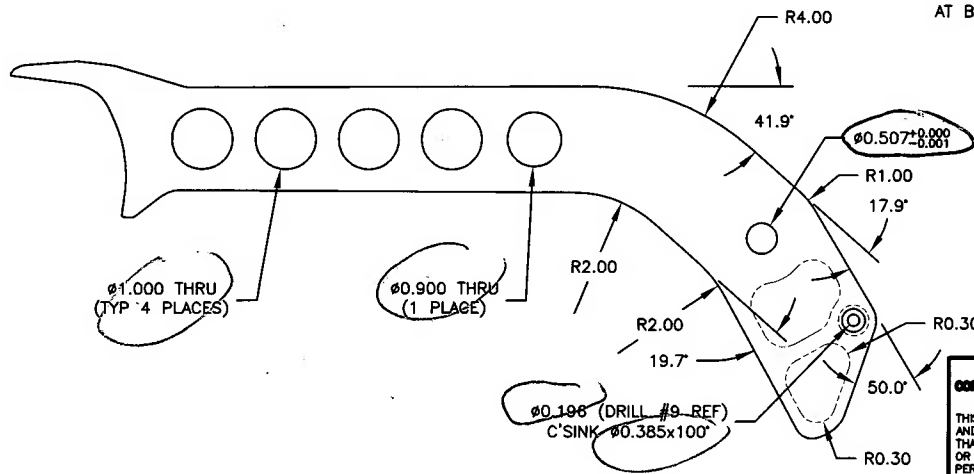
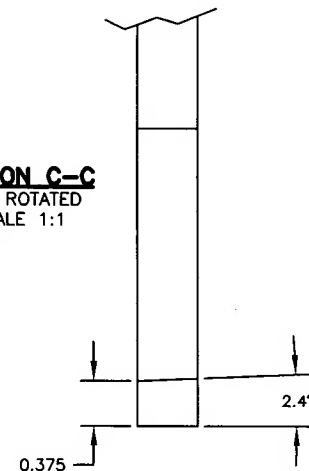


D3560-3 ARM (SHOWN). D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C
VIEW ROTATED
SCALE 1:1



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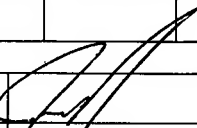
DESIGN	47	DRAWN BY	47	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3560	REV. C SHEET 3 OF 3
DATE	07.04.10	TITLE	ARM WELDMENT	SCALE	1:2

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	D3560-4
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	± 0.01	0.188	✓			
0.507	$+0.000$ -0.001	0.506	✓			
0.250	± 0.01	0.249	✓			
1.702	"	1.701	✓			
1.750	"	1.748	✓			
0.250	"	0.251	✓			
<hr/>						
0.188	± 0.01	0.187	✓			
0.500	"	0.501	✓			
<hr/>						
0.507	$+0.000$ -0.001	0.507	✓			
0.385x100°	± 0.01	0.390x100°	✓			
0.196	$+0.005$ -0.001	0.197	✓			
0.900	$+0.007$ -0.001	0.901	✓			
0.000	"	0.000	✓			

Measured by:		Audited by:		Prototype Approval:	
Date:	07.04.20	Date:	07.04.20	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	